

(19)



JAPANESE PATENT OFFICE

74427

PATENT ABSTRACTS OF JAPAN

(11) Publication number: 10323828 A

(43) Date of publication of application: 08.12.98

(51) Int. Cl

B29B 9/06

B29C 47/40

(21) Application number: 09135179

(71) Applicant: JAPAN STEEL WORKS LTD:THE

(22) Date of filing: 26.05.97

(72) Inventor: HANDA KIYOSHI
KUBOTA KANSABURO
ODA NORIKIYO

(54) METHOD AND APPARATUS FOR
MANUFACTURING THERMOPLASTIC RESIN
PELLET

disposed via a small interstice G of about 1 mm to 2 mm from the tip of the screws 3, 4.

(57) Abstract:

PROBLEM TO BE SOLVED: To pelletize material extruded from a kneading machine directly by performing extrusion in a state of the tip end of a screw of a biaxial kneading extruder put in the proximity of the inner surface of dies in a manufacturing method of pellets by melt kneading resin material with a biaxial kneading extruder, and extruding molten material from dies to be granulated subsequently.

SOLUTION: A granulating machine 6 comprising dies 5 and a cutter unit is connection secured at the tip of a biaxial kneading extruder 1. The die's 5 is substantially in the shape of a disk, and on the back surface thereof, two conical recesses 5a are formed adjoining in conformation with the distal end configurations of screws 3, 4, followed by forming a plurality of dies holes that pierce in the direction of thickness. In addition, the dies 5 has a flow path for temperature control fluid formed penetrating in the board face direction around the dies holes. The flow path is connected with a temperature control fluid pipe. The dies 5 is made such that the back face recesses 5a are

